

WORK ORDER

Order Date: 16/01/06
D / M / Y

W.O. Number # 2006-01
Current yyyy - 000

Customer Purchase Order: _____

Expected Completion Date: _____

NOTE: A new file must be opened for each work order and a unique sequential number assigned.

This Work Order is part of a set of Incorporated Documents referenced in the Quality Program Manual of AERO Design Ltd. as Process Control Forms. It has been developed in compliance with the quality records requirements of an Approved Manufacturing Facility of aeronautical parts and products under CARS PART V Chapter 61, and AWM Advisories 561/1, 2, 3A & 4 effective January 1, 1986.



President, AERO Design Ltd.

A. PREPARATION

1. Type Approval Authority

All work detailed in this Work Order is to be completed in accordance with:

Supplemental Type Certificate: SH00-48 Issue: 4

2. Scope of Work

a) Complete Product

☐ Fabrication of _____
Qty Item

☐ Traceability: Serial Numbers: From # _____ To # _____
xxx-xxx xxx-xxx

☐ Document Serial Numbers in this Work Order Section D - Final Inspection & Sign-Off of Aeronautical Products

☐ Record Serial Numbers in Serial Number Control List [Form 010].

OR

b) Component Parts

☒ Fabrication of component parts of Forward Landing Gear Fittings / Beams
as detailed in this Work Order Section B - Parts List.

☐ Traceability: finished parts will be indelibly marked with this Work Order Number.

Notes: _____

10x 49311-01

4x 49221-01

3x 49221-02

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3. Work Order Package Preparation

☐ Document Control List for _____ issue _____; DCL _____ Rev. ____

☐ Full set of new drawings for complete fabrication.

OR

☒ Partial set of ~~new~~ drawings for parts fabrication:

Drawing List: 49221, Revision 1; 49311, Revision 1

49320, Rev 1

Notes: _____

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B. PARTS LIST

- ☐ **Complete fabrication:** This list may *not* be used as Final Inspection Record.
- ☒ **Partial fabrication:** This list may be used as Final Inspection Record.

Qty	Part No.	Description	Materials	Tracking Number PO# for raw stock WO# for finished component parts	Final Inspection
					(Parts mfg only) Accept (A) Non-Conforming (NC)
10	49311-01	FWD LDG GEAR FTG	6061-T6 AL PLATE	5017/5005	A
4	49221-01	FWD BEAM	6061-T6 1x3	5035	A
3	49221-02	AFT BEAM	"	5035	A
10	49320-01	Barrel NH	304 S.S- 3/4 Dia Rod	4072	A

Notes: _____

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C. INSPECTION & SIGN-OFF OF COMPONENT PARTS & ASSEMBLIES

1. Inspection of Welded Assemblies

I hereby certify that I have inspected the welding of the aeronautical parts and assemblies specified in this Work Order and have found it to be complete and conforming to the requirements specified in the Work Scope, except where specifically identified and noted as non-conforming.

Date

Welder's Signature

License #

2. Inspection of Component Parts

I hereby certify that I have inspected the aeronautical component parts manufactured under this Work Order and have found them to be in conformity to the Approved Design Data specified within the Work Scope, except where specifically identified and noted as non-conforming.

Jan 19/06
Date

Jeff Clarke
Inspector's Signature

D. FINAL INSPECTION & SIGN-OFF OF AERONAUTICAL PRODUCTS

ITEM	SERIAL NUMBER	ACCEPT YES/NO	NON-CONFORMANCES Non-Conformance Report #'s	ADDITIONAL REMARKS
1				

I hereby certify that I have inspected the aeronautical component parts manufactured under this Work Order and have found them to be in conformity to the Approved Design Data specified within the Work Scope, except where specifically identified and noted as non-conforming.

Date

DAR or Inspector's Signature

DOCUMENT CONTROL LIST

DOCUMENT NO.	DOCUMENT CONTENT	REVISION
INSTALLATION DOCUMENTS		
49201	Cargo Basket Installation	1
FMS492.01	Flight Manual Supplement	1
MI492.01	Maintenance Instructions	3
FABRICATION DOCUMENTS		
49205	Cargo Basket Assembly	1
49207	Cargo Basket Lid	1
49208	Cargo Basket Body	1
49209	End Hoop Assembly	1
49210	Basket Components – Hoops	1
49211	Basket Components – Rim	1
49212	Basket Components – Rim	0
49213	Basket Components – Lid Brace	1
49214	Basket Components – Spine	0
49215	Basket Components – Spacer	0
49216	Basket Components – Spacer	0
49217	Basket Components – Lug	1
49218	Placard	1
49219	Spacer	0
49221	Support Beams	1
36255	Handle Assembly	1
36261	Handle Bar Assembly	1
36262	Handle Bracket Assembly	1
36271	Handle Lever	0
36272	Basket Bracket	0
36273	Lid Bracket	0
36274	Bushing	0
36275	Bushing	1
36276	Spring Hook	0
36277	Handle Bar	0
36278	Spring	1
36280, Sheet 1	Brace	2
36280, Sheet 2	Brace	2
ENGINEERING DOCUMENTS		
ER492.01	Engineering Report – Basket Installation	0
ER492.02	Engineering Report – Basket Load Tests	0
APPROVAL:	ORIGINAL DATE: 17 May, 2002 REVISION DATE: 20 July, 2004	AERO DESIGN LTD. 2013 – 39 th Ave. NE Calgary, Alberta T2E 6R7 Ph. (403) 250-8027 Fax. (403) 250-8333
	SHEET 1 OF 1	BELL 206L SERIES Side-Mounted Cargo Basket Installation
	<div> <div>DCL492</div> <div>Rev. 4</div> </div>	

- AMO 91-02 -



Unit #1, 19158 94 Ave., Surrey, BC V4N 4X8

JOB No.

2374



Nomenclature: Gear Fitting.

Part No. 49346 Serial No. N/A 1st

Customer Aero Design

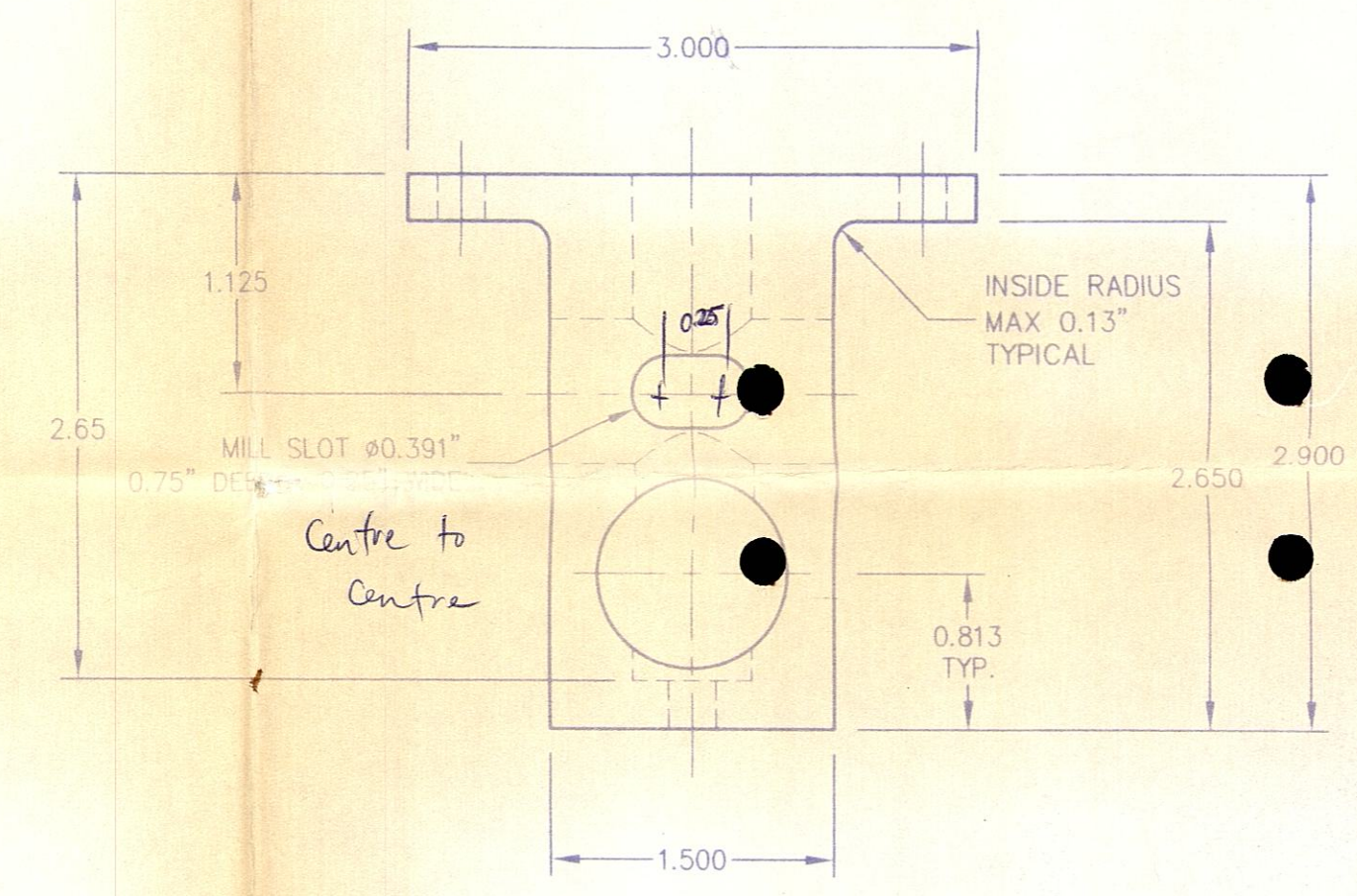
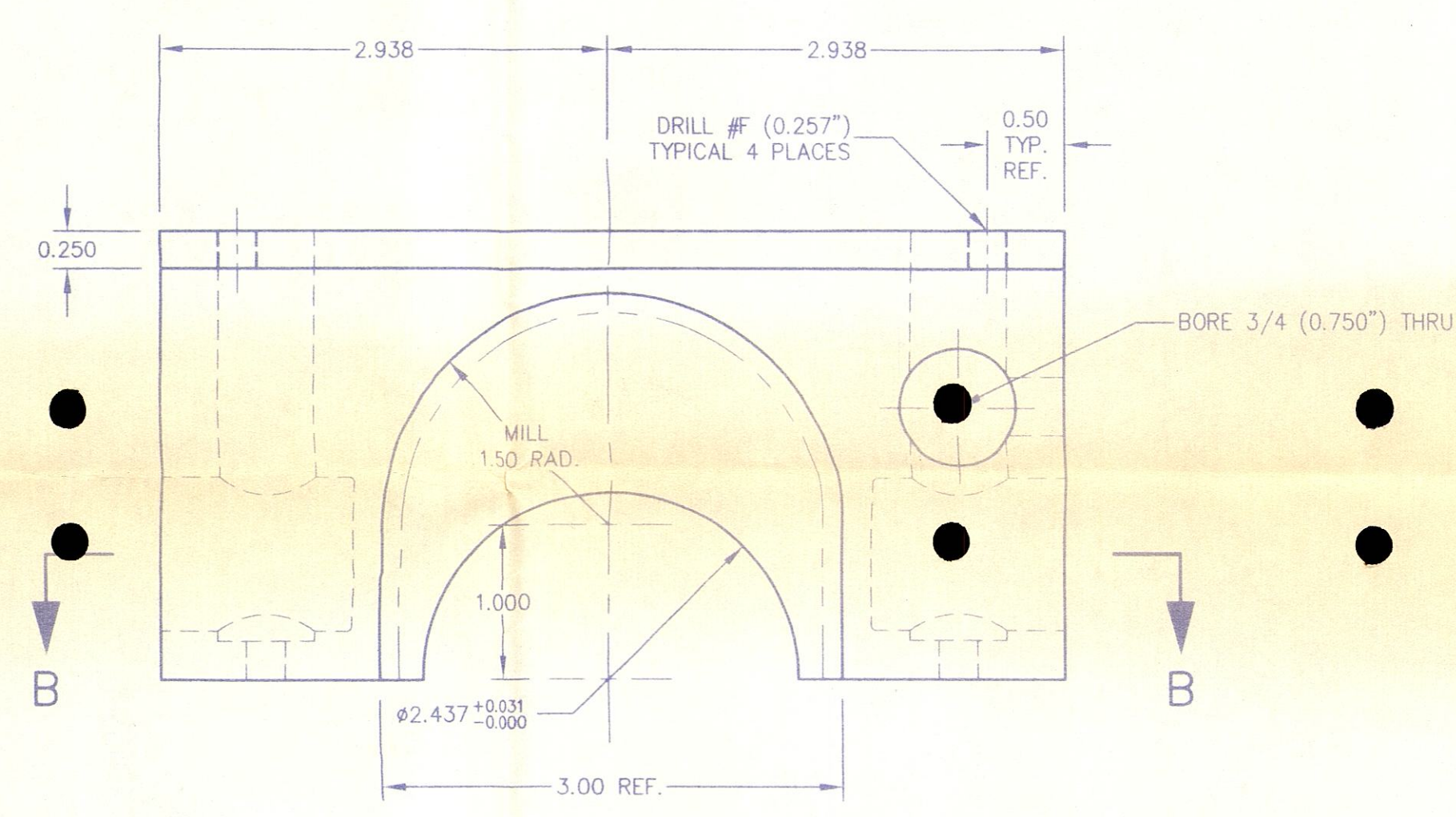
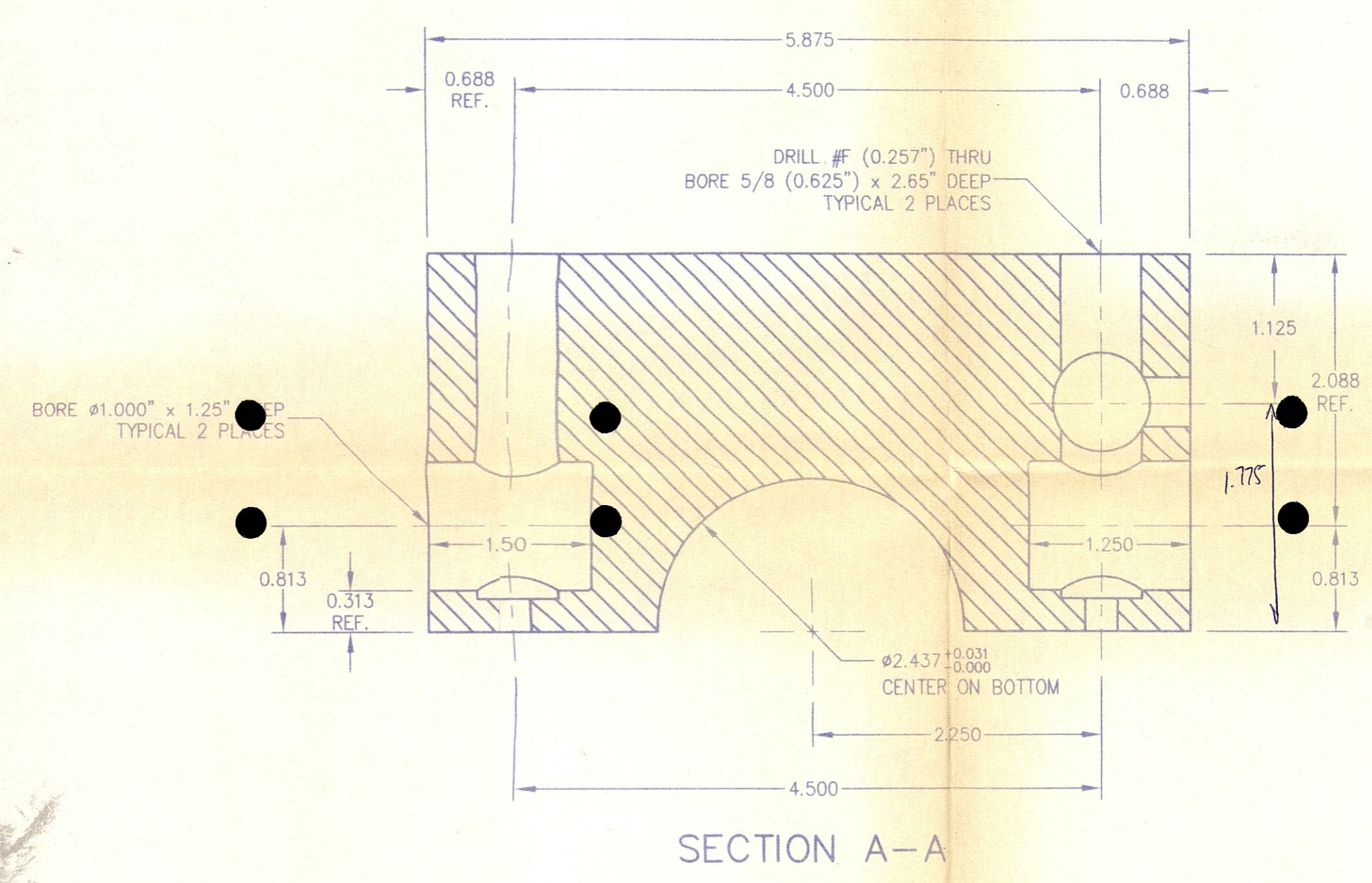
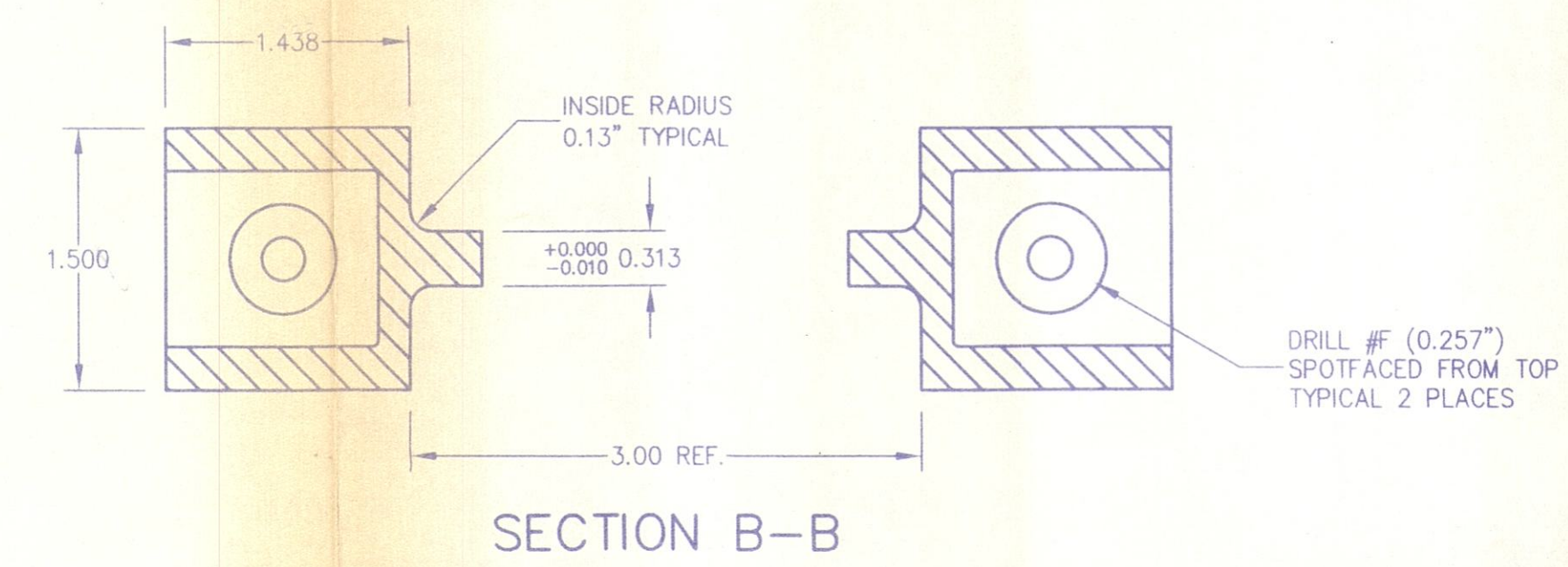
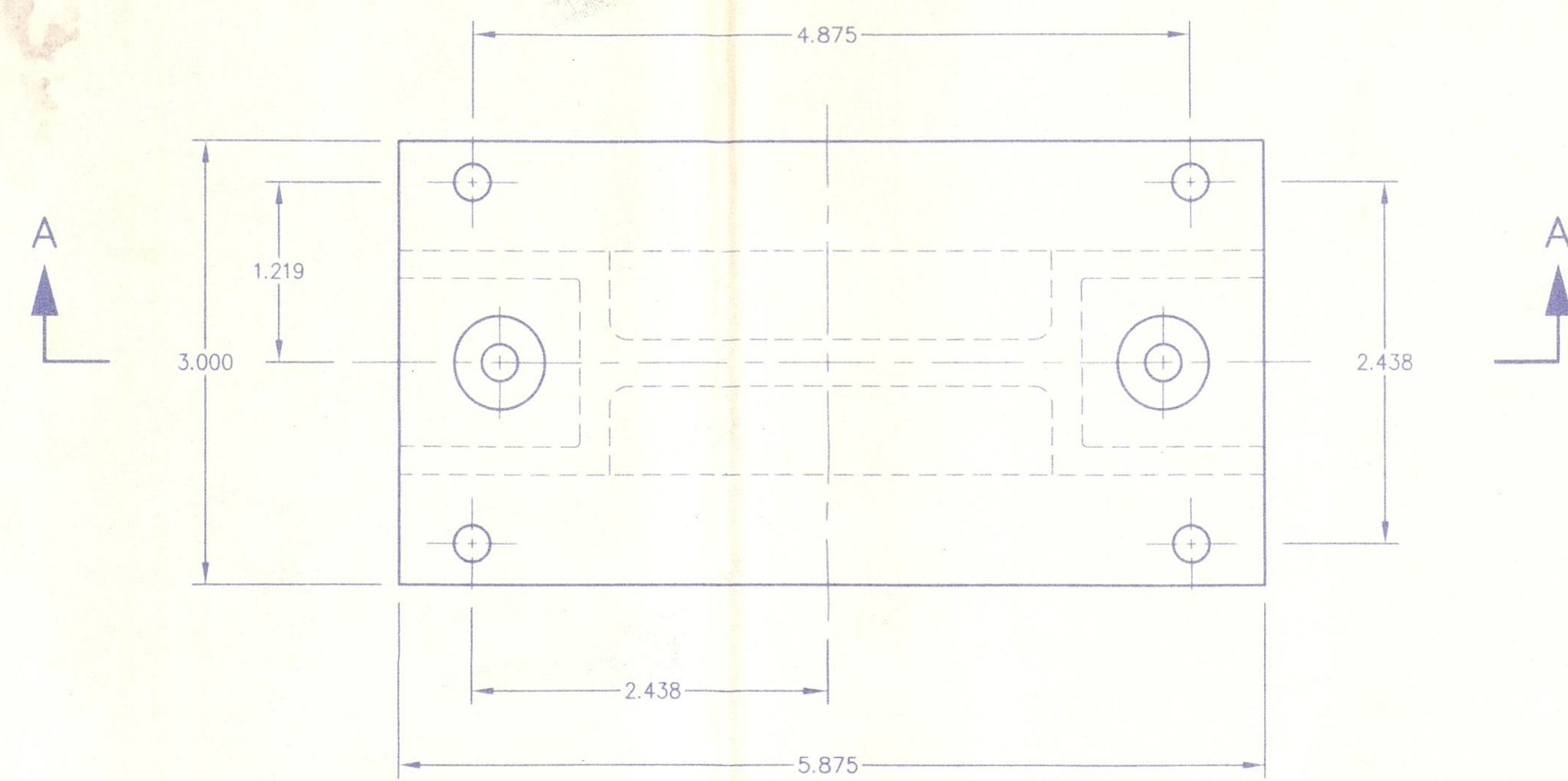
New ☒ Overhaul ☐ Repair ☐ Inspected ☐

Date April 5, 05 Inspector's Signature Stamp [Signature]

SERVICEABLE

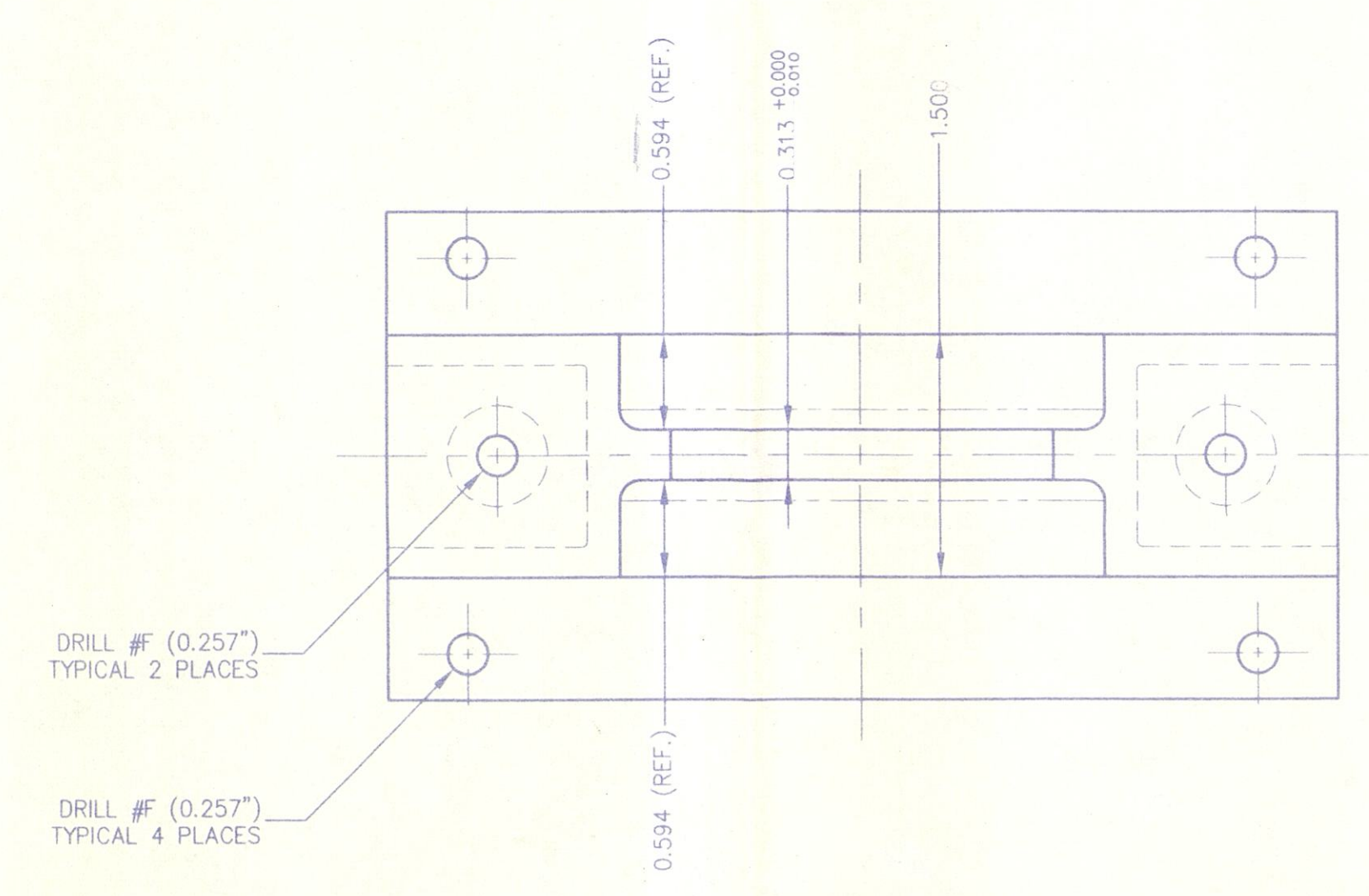
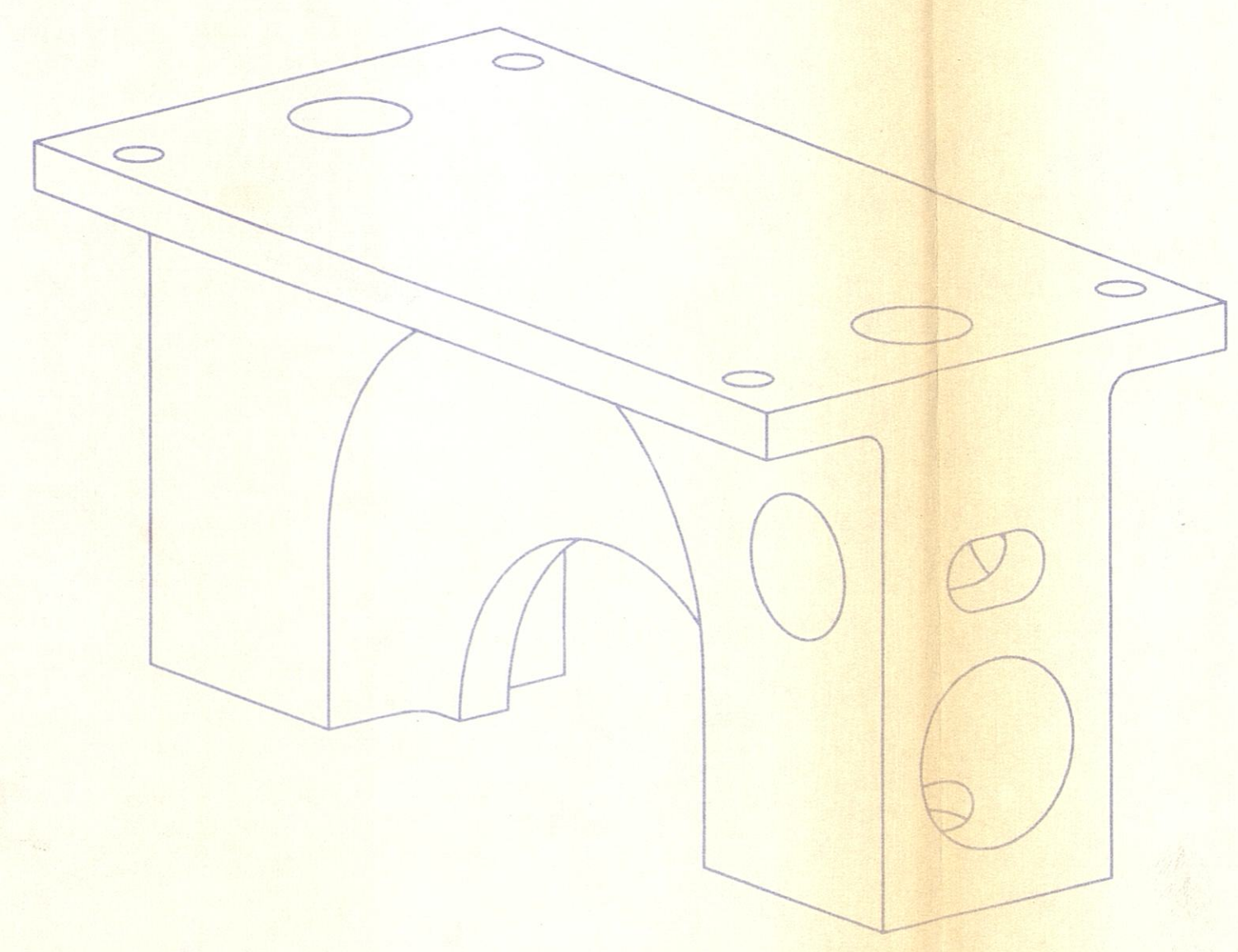
● 5017

NOTICE			
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	MANUFACTURING CHANGE: SIDE MOUNTED BARREL-NUT, BEARING DIAMETER INCREASED, FLANGE REDUCED FROM 0.40" TO 0.25" PER ER493.03	STF	JUN 17/02
2	ADDED REFERENCE DIMENSIONS	STF	MAY 03/04



01 FORWARD FITTING

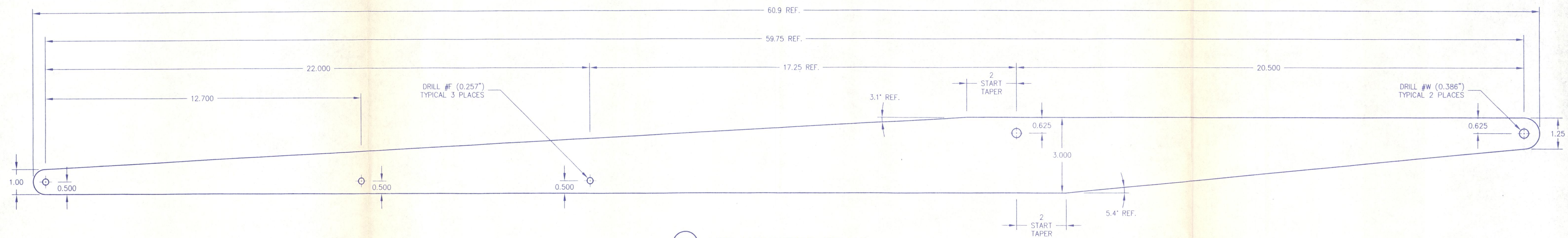
- NOTES:
1. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
 2. THOROUGHLY CLEAN, EPOXY PRIME, AND PAINT PART PRIOR TO ASSEMBLY.



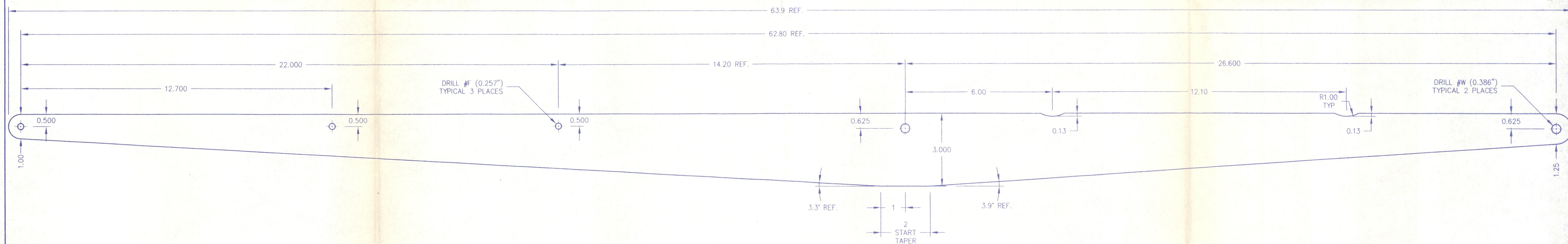
2	49311-01	01	FORWARD FITTING	6061-T651 ALUMINUM	QQ-A-250/11	3.0" PLATE	
	PART NO.	ITEM	DESCRIPTION	MATERIA.	MATERIAL SPEC.	STOCK SIZE	
QTY.	LIST OF MATERIALS						
APPROVALS			DATE				
DRAWN: STEVEN FAHEY			APR 24/02				
CHECKED: E. BURGAIN			APR 24/02				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net				
			BELL 206L SERIES EXTERNAL ATTACHMENT PROVISIONS FORWARD FITTING				
			SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1		A1	49311	2

NOTICE
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADDED CUTOUTS TO FORWARD BEAM	BJC	13 MAY 2004
2	ADDED 0.25" HOLE 12.700" FROM END HOLE	BJC	14 OCT 2004



02 AFT MOUNTING BEAM



01 FORWARD MOUNTING BEAM

QTY.	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
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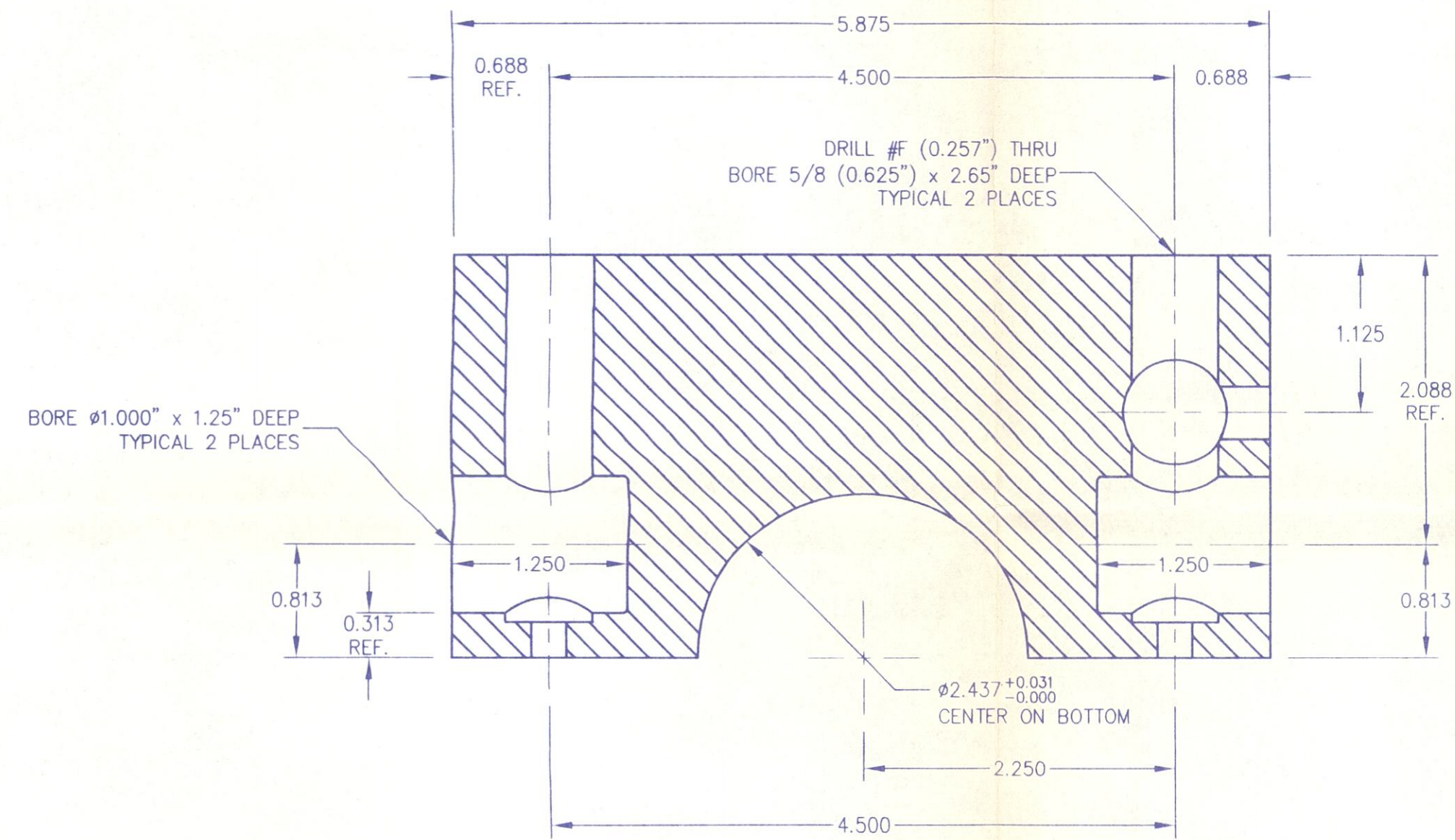
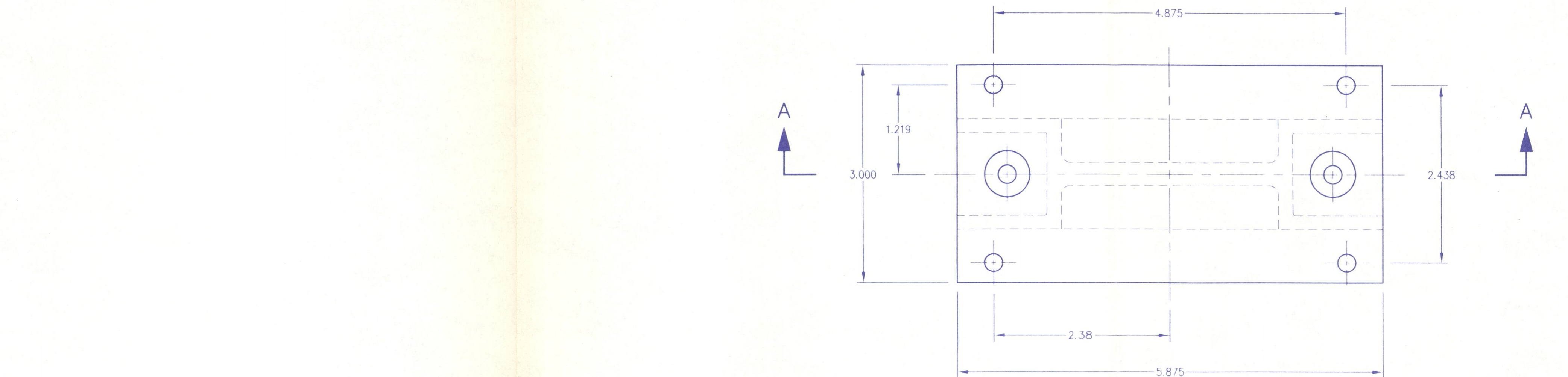
QTY.		LIST OF MATERIALS			

AERO DESIGN LTD.
ENGINEERING CONSULTANTS
1045 McTAVISH ROAD N.E.
CALGARY, ALBERTA T2E 7G9

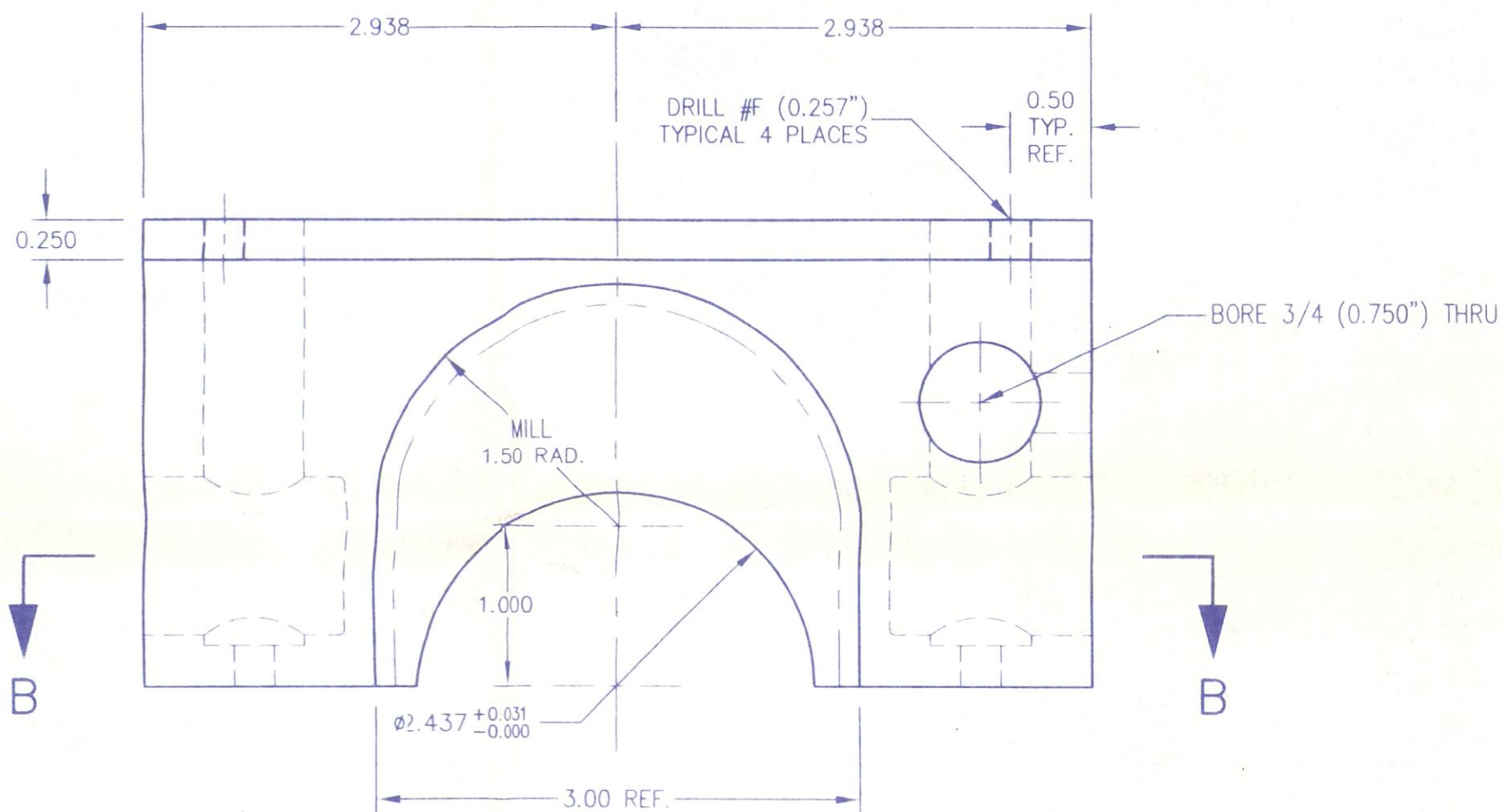
BELL 206L SERIES AND 407
SIDE MOUNTED CARGO BASKET
FORWARD AND AFT MOUNTING BEAMS

SCALE 1 : 2	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	49221	2

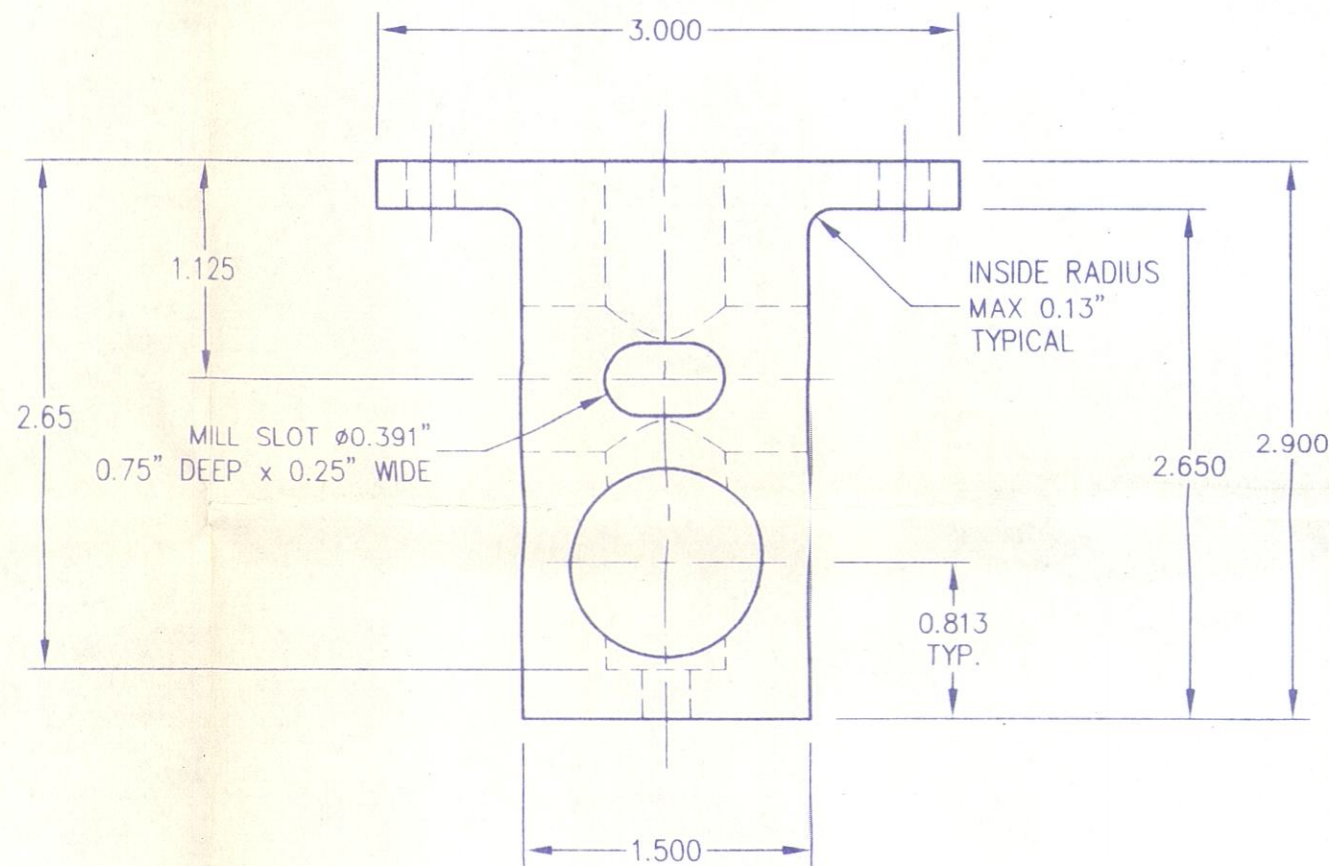
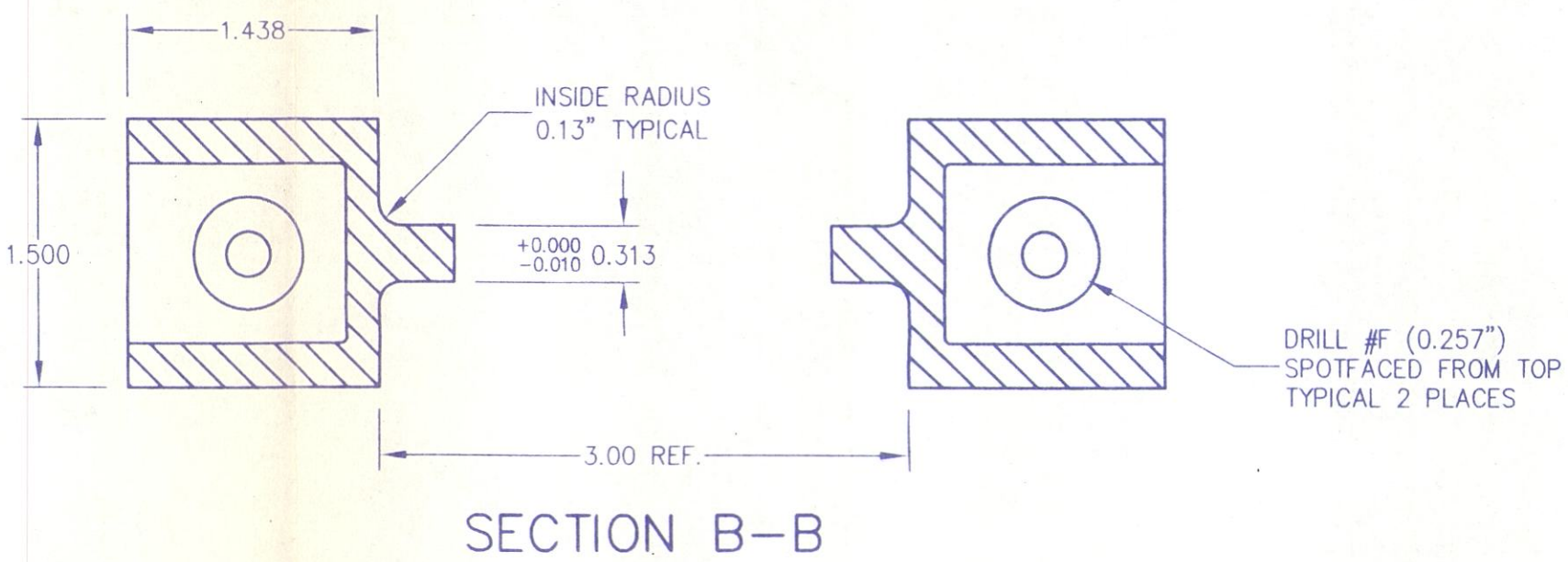
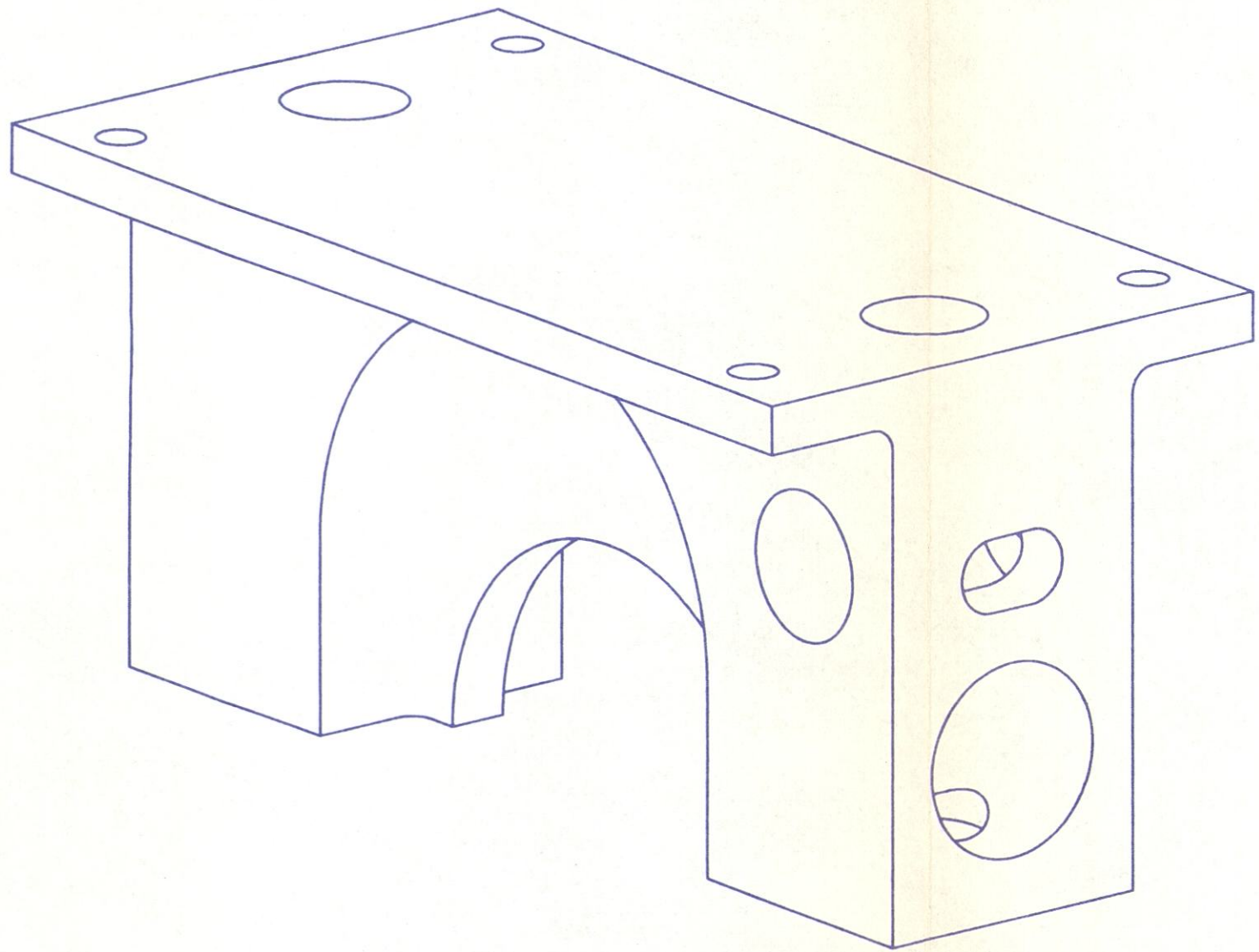
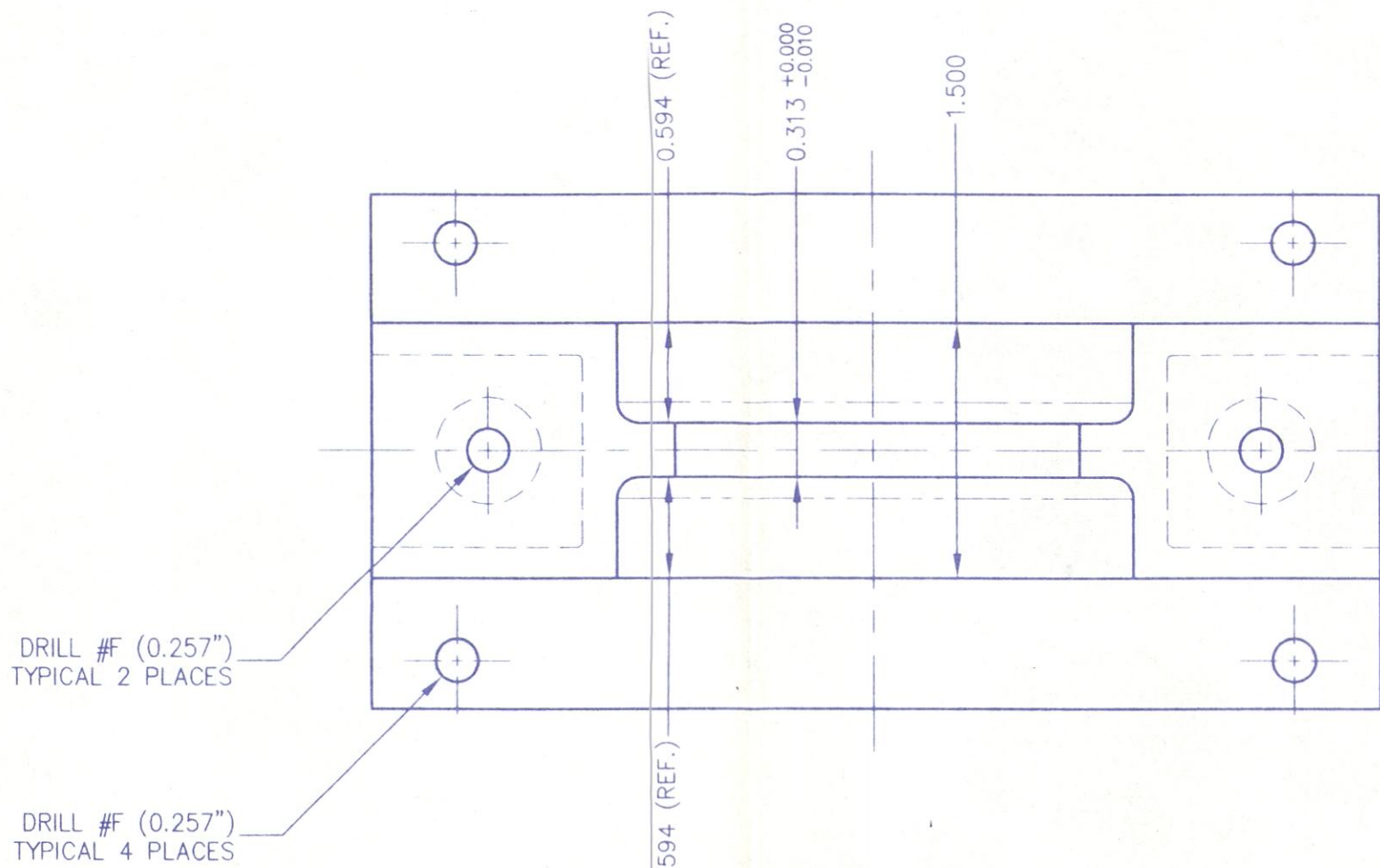
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REV.	DESCRIPTION OF CHANGE		INITIALS
1	MANUFACTURING CHANGE: SIDE MOUNTED BARREL-NUT, BEARING DIAMETER INCREASED, FLANGE REDUCED FROM 0.40" TO 0.25" PER ER493.03		STF
			DATE
			JUN 17/02



SECTION A-A



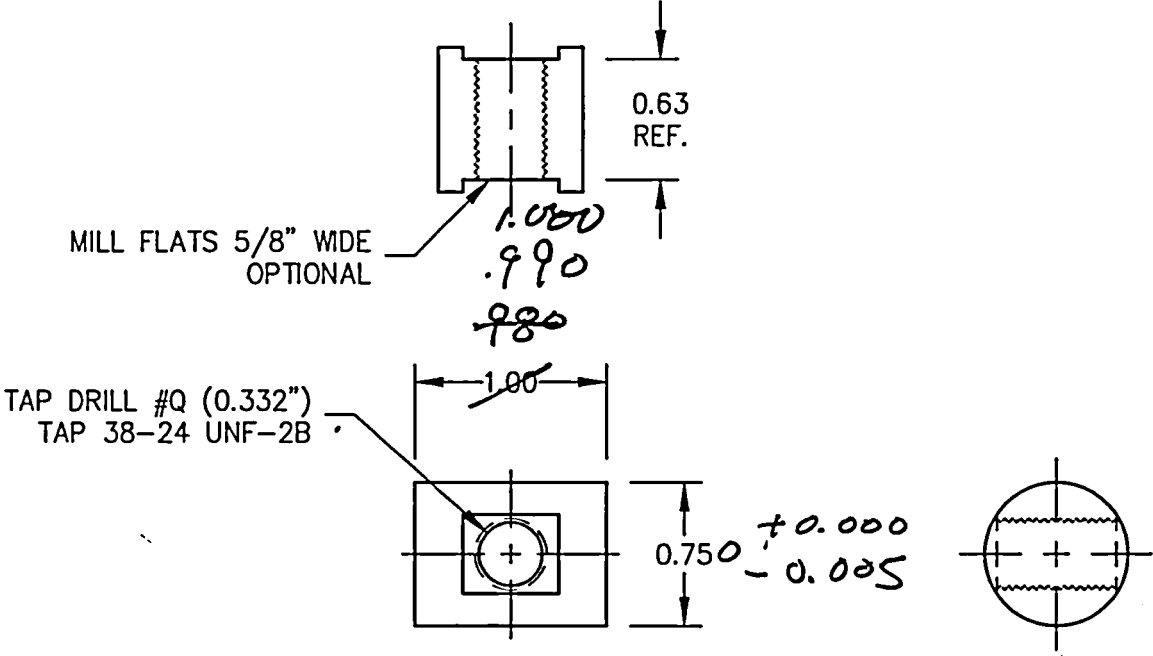
01 FORWARD FITTING



- NOTES:
1. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
 2. THOROUGHLY CLEAN, EPOXY PRIME, AND PAINT PART PRIOR TO ASSEMBLY.

2	49311-01	01	FORWARD FITTING	6061-T651 ALUMINUM	QQ-A-250/11	3.0" PLATE
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
QTY. LIST OF MATERIALS						
APPROVALS			DATE			
DRAWN: STEVEN FAHEY			APR 24/02			
CHECKED: E. BURGAIN			APR 24/02			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net			
DECIMALS			BELL 206L SERIES EXTERNAL ATTACHMENT PROVISIONS FORWARD FITTING			
X.XXX ±0.010			REV.			
X.XX ±0.03			CHG.			
X.X ±0.1						
SCALE 1 : 1			DWG. SIZE		DWG. NO.	
SHEET 1 OF 1			A1		49311	
					1	
					A	

LIST OF MATERIALS					
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
49320-01	01	BARREL NUT	AISI 304 SS	MIL-S-5059	ø3/4" BAR



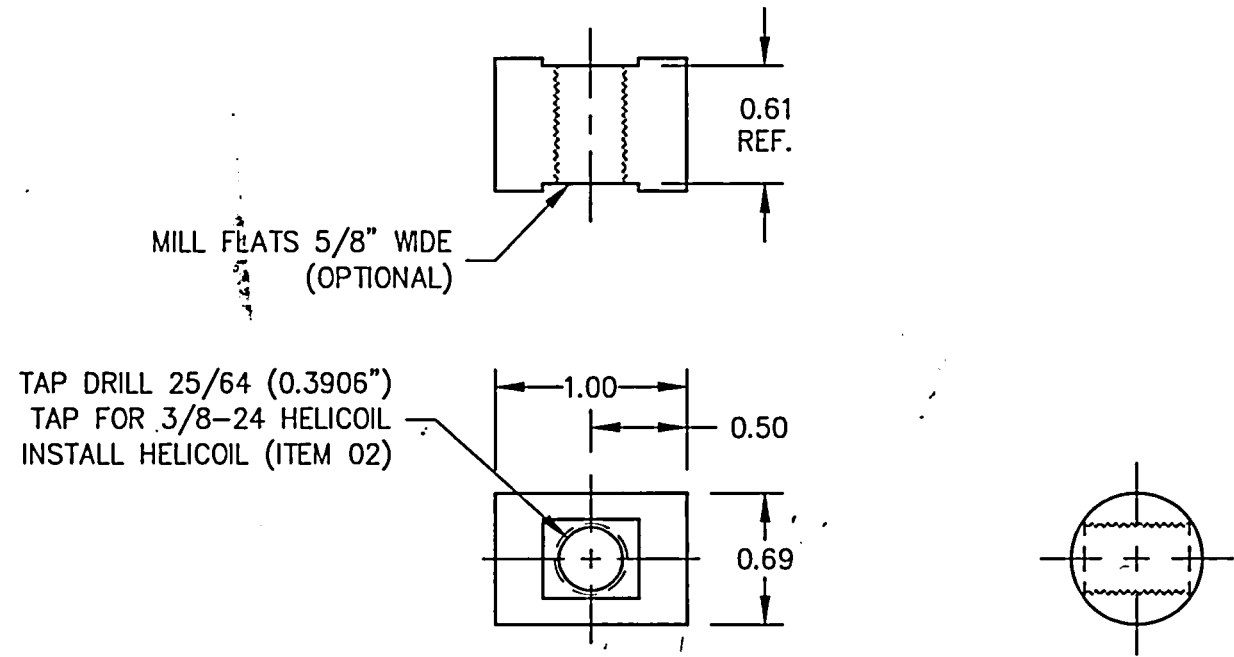
01 BARREL NUT

NOTES:
1. REMOVE ALL BURRS AND SHARP EDGES.

APPROVALS		DATE		AERO DESIGN LTD. ENGINEERING CONSULTANTS 1045 McTAVISH ROAD N.E. CALGARY, ALBERTA T2E 7G9			
DRAWN: STEVEN FAHEY		MAY 10/02					
CHECKED: E. BURGOIN		MAY 10/02					
STRESS:							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				BARREL NUT FABRICATION			
				SCALE 1 : 1		DWG. SIZE	
		SHEET 1 OF 1		LGL		49320	
						REV. 1	

1	ENLARGED TO FIT LARGER HOLE.	STF	JUN 24/02
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
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LIST OF MATERIALS					
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
60624-01	01	BARREL NUT	AISI 304 SS	MIL-S-5059	Ø11/16" BAR
3591-6CN	02	SELF-LOCKING THREAD INSERT	HELICOIL	-	3/8-24 UNF x 9/16" LONG



01 BARREL NUT

NOTES:
1. REMOVE ALL BURRS AND SHARP EDGES.

0	CREATED FROM 49320, REV. 1	BJC	MAR 29/04
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE

NOTICE

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APPROVALS		DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net				
DRAWN: JEFF CLARKE		29 MAR 2004					
CHECKED: E. BURGAIN							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1			BELL 407 EXTERNAL ATTACHMENT PROVISIONS BARREL NUT FABRICATION				
			SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1		A1	60624	0